

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003259**Date Inspected:** 17-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Keng Chan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing Island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 1**Skin A South Tower Assembly**

The Quality Assurance Inspector observed tack welding and fit up operations has been completed on skin A South Tower Assembly. The Quality Assurance Inspector observed ZPMC personnel in process of repairing tack welds by grinding.

The Quality Assurance Inspector observed ZPMC in process of performing thermal cutting on diaphragm plate P967A.

The Quality Assurance Inspector observed ZPMC in process of performing a survey on skin plate D South Tower Assembly.

Skin E South Tower Assembly

The Quality Assurance Inspector observed ZPMC welder 053673, utilizing the flux cored arc welding process on a weld repair discover during ultrasonic inspection on SSDI-SA173 A/K 20B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification

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WPS-345-FCAW-1G(1F) Repair.

Bay 2

Longitudinal Stiffener

The Quality Assurance Inspector observed ZPMC welder 053316, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number ESDI-SA49 A/D 7B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

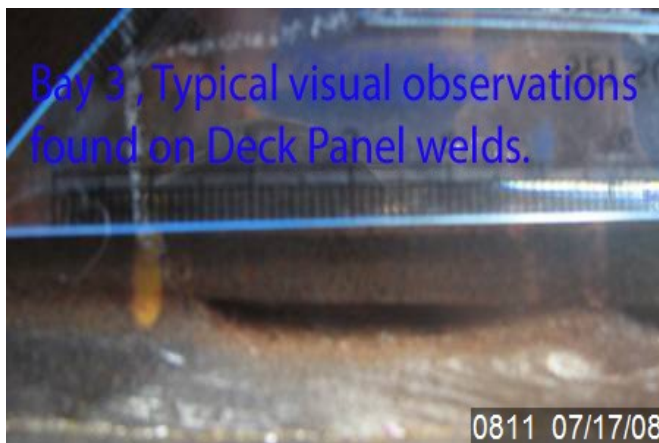
The Quality Assurance Inspector observed ZPMC welder 040775, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number ESDI-SA49 A/D 8B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

The Quality Assurance Inspector observed ZMPC in process of performing thermal cutting operations on diaphragm plate SA238.

Bay 3

The Quality Assurance Inspector observed ZPMC grinding and performing flux core arc welding (FCAW) on visual weld repairs on Orthotropic Box Girders (OBG)DP-0830-001, DP-049-001, and DP-001-001 .

The Quality Assurance Inspector performed a random initial visual observation on Orthotropic Box Girders (OBG)DP-407-001 and DP-245-001. The Quality Assurance Inspector observed several areas of underfill and undercut. ZPMC and American Bridge/Fluor Quality Control Inspector agreed with the visual observations found by the Quality Assurance Inspector. ZMPC Quality Control Inspector informed the Quality Assurance Inspector, he will contact the Quality Assurance Inspector when the repairs are complete.



Summary of Conversations:

No relevant conversations on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara,Raymond
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Quality Assurance Inspector

Reviewed By:	Lanz,Joe
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QA Reviewer
